

Work Order ID 149932

Monday, August 15, 2016 10:07:35 AM

149932

Page 1

Item ID: D4867-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206L FWD Leg Assembly
Start Date: 8/9/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 8/22/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: **AUG 15 2016** Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4867	C								
110		0.00							
110									
Small Fab	Memo	0.72							
Small Fab	ALIGN PILOT HOLES IN D4867-1 WITH PILOT HOLES IN D4871-1 AND D4871-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9964 AS PER DWG.								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.03							
Quality Control									

AUG 16 2016

8 FF

DAS
38
9-89

AUG 16 2016

③

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
2025 01 04				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						8	FF	AUG 18 2016	
Small Fab	Memo	0.64							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9964 A/R HYSOL BATCH: <u>M134167</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.03							
Quality Control									
									DAS 38 9-89 AUG 18 2016
150	Outsource process - Laser Marking	0.00							
150									
Outsource9	Memo	223.99							
Outsource process - Laser Marking	ISSUE P/O : <u>33376</u> OUTSOURCE VENDOR: P&L PRINTING ENGRAVE P# AS PER DWG C OF C IS REQUIRED								
									DAS 13 9-89 AUG 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 149932

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149932

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Item Name: 206L FWD Leg Assembly
Start Date: 8/9/2016 Start Qty: 8.00 ***8*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.03							<u>8x 8/16-9-7</u>
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03							<u>8</u> DAS 38 9-89 SEP 08 2016
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>St231</u> Memo	0.00 0.01							<u>8</u> DAS 6 9-89 SEP 09 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89	SEP 0 9 2016	
190 QC	Memo	0.13							
Quality Control								DAS 21 9-89	SEP 0 9 2016

DQA: _____ Date: _____



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Work Order update only ☐

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Picklist Print

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Work Order ID: 149932

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Parent Item: D4867-041

D4867-041

Parent Item Name: 206L FWD Leg Assembly

Start Date: 8/9/2016

Required Date: 8/22/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.01.15 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB5-12 *HI 32PB5-12* Hi-Lok Pin		Purchased	No				Each	179.0000		32			
									**		FF	AUG 16 2016	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST553				179					
					M129912			179		32			
D4867-1 *D4867-1* Strut		Manufactured	No				Each	4.0000		8			
									**		FF	AUG 16 2016	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST130				4					
					121574			4		8			
D4871-1 *D4871-1* End Fitting		Manufactured	No				Each	27.0000		8			
									**		FF	AUG 16 2016	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST131				27					
					121490			27		8			
D4871-3 *D4871-3* End Fitting, Eye		Manufactured	No				Each	28.0000		8			
									**		FF	AUG 16 2016	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST131				28					
					121694			28		8			

***NOT PULLED**

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																						OTHER :																																									

Picklist Print

Monday, August 15, 2016 10:07:38 AM

Page 2

Work Order ID: 149932

149932

Parent Item: D4867-041

D4867-041

Parent Item Name: 206L FWD Leg Assembly

Start Date: 8/9/2016

Required Date: 8/22/2016

Start Qty: 8.00

Required Qty: 8.00

HL86-5

Purchased

No

Each

600.0000

32

HI 86-5

FF

AUG 16 2016

Hi-Lok Collar

Location

Loc Qty

Loc Code

ST562

600

M128228

3

M129022

200

M129864

397

32

Monday, August 15, 2016 10:07:38 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER :																									

Work Order Detail

Monday, August 15, 2016 10:30:19 AM

Criteria : All Sales Orders Work Order ID: 121689 Item ID: D4867-041 Product Family SMALL FAB Work Order Status Costed Work Order Type Standard
All Start Dates All Required Dates
Sorted by WO ID

Work Order ID	Item ID	Item Name	Reference SalesOrder I	Status Code	Start Date	Req. Date	Last Work Date	Start Qty	Required Qty	Complete Qty	Remaining Qty
121689	D4867-041	206L FWD Leg Assembly		Costed	6/26/2014	6/26/2014	4/21/2015	8.0000	8.0000	0.0000	8.0000

Work Order ID: 121689

Parent Item: D4867-041

Parent Item Name: 206L FWD Leg Assembly

121689

D4867-041

Start Date: 6/26/14**Required Date:** 6/26/14**Start Qty: 8.00**

Required Qty: 8.00

Comments: IPP REV:A 14.01.15 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4867-1 *D4867-1* Strut		Manufactured	No		121574		Each	0.0000		8			
D4871-1 *D4871-1* End Fitting		Manufactured	No		121490		Each	3.0000	**	8			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST124			3						
					112018		3						
D4871-3 *D4871-3* End Fitting, Eye		Manufactured	No				Each	3.0000	**	8			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST124			3						
					117329		3						
HL20PB5-12 *HI 20PB5-12* Rivet		Purchased	No				Each	176.0000	**	32			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST265			176						
					M128110		34						
					M128973		142						

REFERENCE ONLY

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO33376

Purchase Order Date 8/19/2016

PO Print Date 9/7/2016

Page Number 2 of 3

Order From : VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-931-1241

Ship To Contact
Ship To Phone
Ship Via: FedEx Economy collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: \$10.00

4 149932

D4867-041 LEG
ASSEMBLY

9/7/2016

Yes

9/7/2016

8.00

\$5.00

\$40.00

LASER MARKED

Line Total: \$40.00

5 146086

D4867-041 LEG
ASSEMBLY

9/7/2016

Yes

9/7/2016

2.00

\$5.00

\$10.00

LASER MARKED

Line Total: \$10.00

6 146794

D4878-041 LEG
ASSEMBLY

9/7/2016

Yes

9/7/2016

2.00

\$5.00

\$10.00

LASER MARKED

Note:

9/7/2016



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE August 31, 2016

P.O NUMBER PO33376

ITEM DESCRIPTION**QUANTITY****COMMENTS**

D4834-041 LEG
D4835-041 LEG
D4836-041 LEG
D4867-041 LEG
D4867-041 LEG
D4878-041 LEG
D4882-042 LEG

2
2
2
8
2
2
2

Laser metal mark part number
Laser metal mark part number
Laser metal mark part number
Laser metal mark part number
Laser metal mark part number
Laser metal mark part number
Laser metal mark part number

SP16-9-7.